

Work Order ID 85604

85604

Page 1

June-12-12 8:48:02 AM

Item ID: D3536-15

Accept

N900040100

Setup Start *NS1*

Revision ID:

20

Item Name: Gasket

Stop *NS2*

Start Date: 12/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

20 0 JM 12-6-19

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

neo .063"

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

20 0 JM 12-6-19

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

6/10/20

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85604

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Page 2

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Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: FP

0.00

130

Packaging

Memo

0.00

Packaging

20

12/06/20 JB

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/20 JB

ML 12/06/20

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Picklist Print

June-12-12 8:48:05 AM

Page 1

Work Order ID: 85604

85604

Parent Item: D3536-15

D3536-15

Parent Item Name: Gasket

Start Date: 12/06/2012

Required Date: 26/06/2012

Star Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	286.1429	0.9848	10.94222			

MNEO60S 063

NEOPRENE SHEET 0.063

**

Jm 12-6-12

Location

Loc Qty

Loc Code

MAT052

286.142884

120948

286.142884

122112

122112

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DART AEROSPACE LTD		Work Order:	85604
Description: Gasket		Part Number:	D3536-15
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15"	✓		MT	HB01
35.65	+/-0.030	35.65"	✓		MT	"
33.65	+/-0.030	33.65"	✓		MT	"
30.15	+/-0.030	30.15"	✓		MT	"
24.90	+/-0.030	24.90"	✓		MT	"
19.65	+/-0.030	19.65"	✓		MT	"
14.40	+/-0.030	14.40"	✓		MT	"
9.15	+/-0.030	9.15"	✓		✓	Production
5.65	+/-0.030	5.65"	✓		✓	mm01
3.90	+/-0.030	3.90"	✓		✓	"
8.00	+/-0.030	8.00"	✓		✓	"
16.00	+/-0.030	16.00"	✓		MT	HB01
24.00	+/-0.030	24.00"	✓		MT	"
0.30	+/-0.030	0.30"	✓		✓	mm01
0.30	+/-0.030	0.30"	✓		✓	mm01
1.89	+/-0.030	1.89"	✓		✓	mm01
Ø0.19	+0.005/-0.001	0.19"	✓		✓	mm01

Measured by: JM	Audited by: S	Prototype Approval:	N/A
Date: 12-6-19	Date: 12/06/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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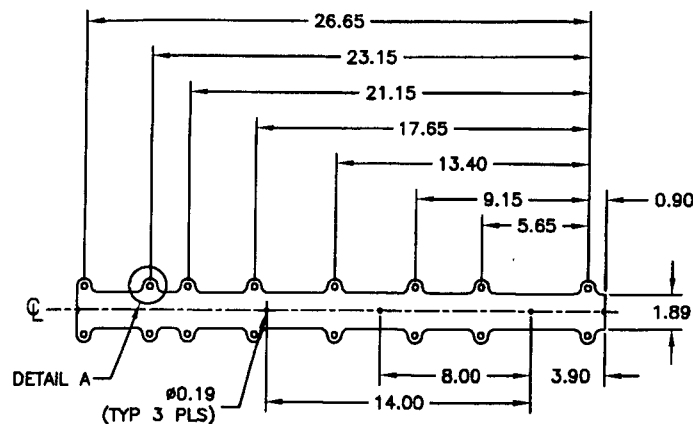
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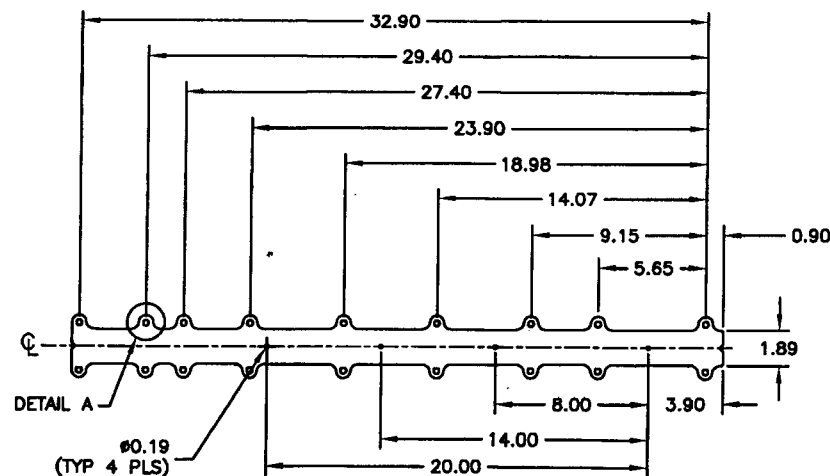
DART

RELEASED
09.02.12-11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85604 MLJ
12/06/12



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

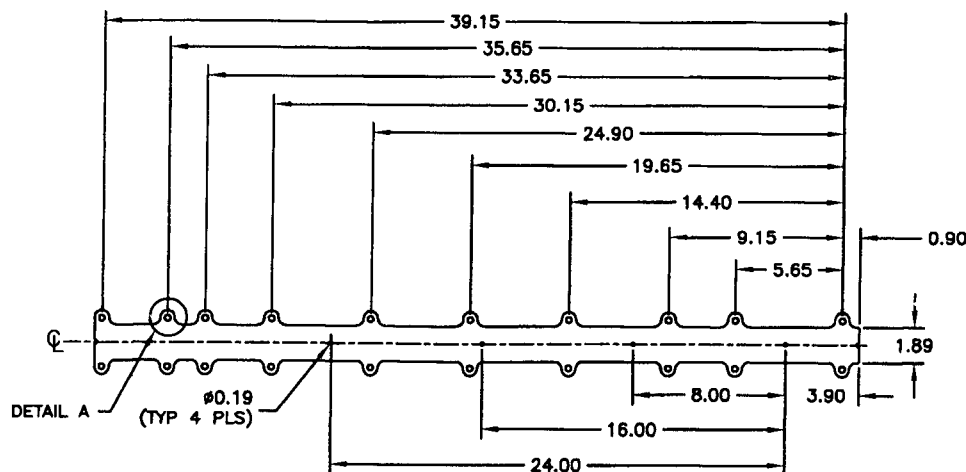
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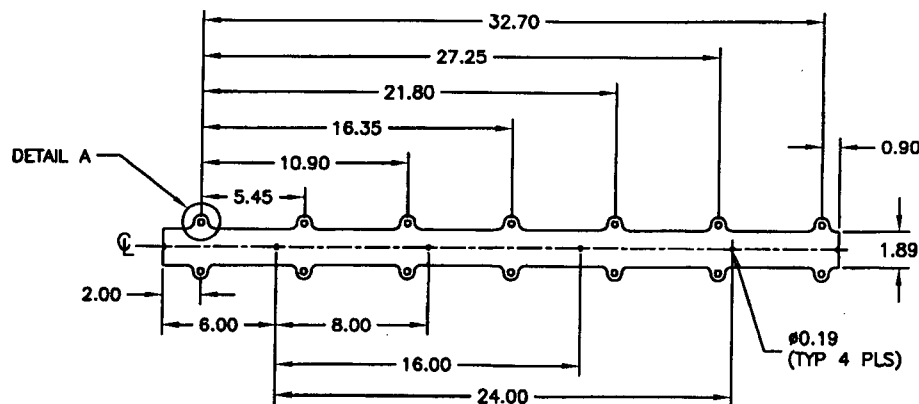


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TITLE	GASKET	SHEET 2 OF 6	SCALE	1:10

RELEASED
0702.12



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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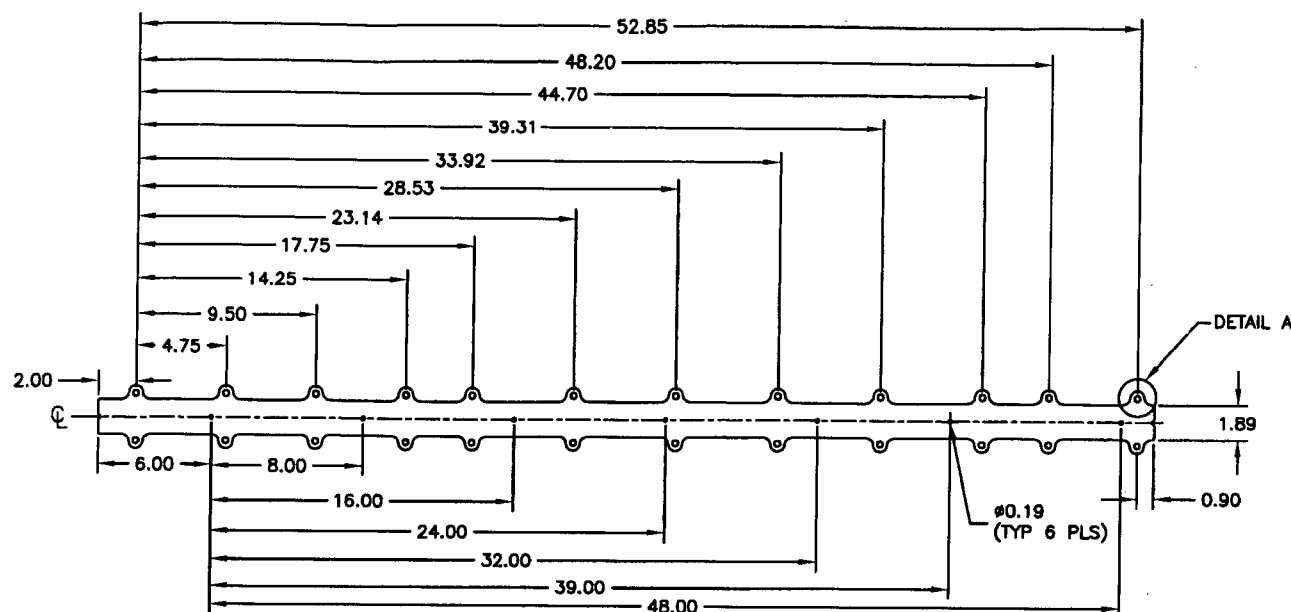
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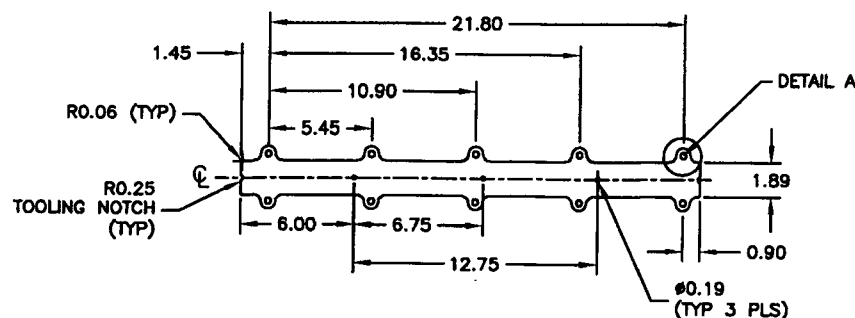
NOTE: Date & initial all entries



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DATE	06.10.25	DRAWING NO.	D3536	REV. A
TITLE	GASKET	SHEET 3 OF 6	SCALE	1:10



D3536-23 GASKET



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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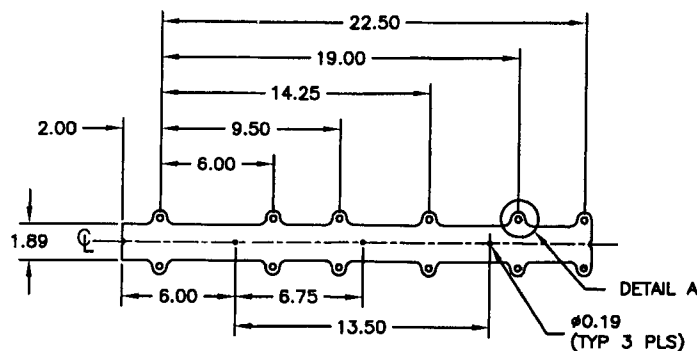
NOTE: Date & initial all entries

DART

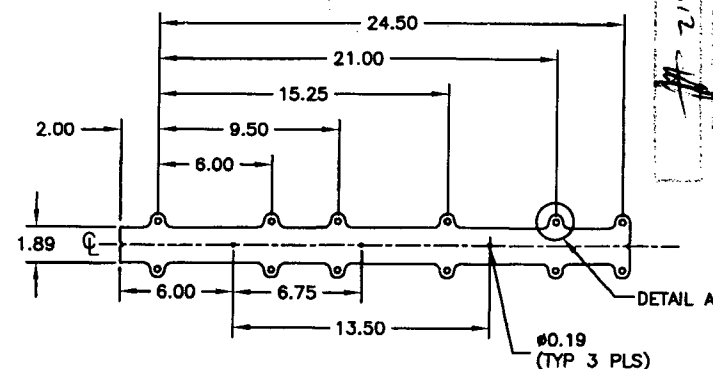
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
TITLE	GASKET	SHEET	4 OF 6	SCALE
				1:10

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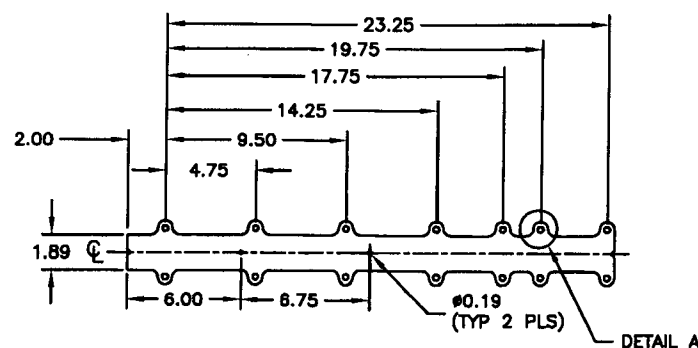
07.02.12



D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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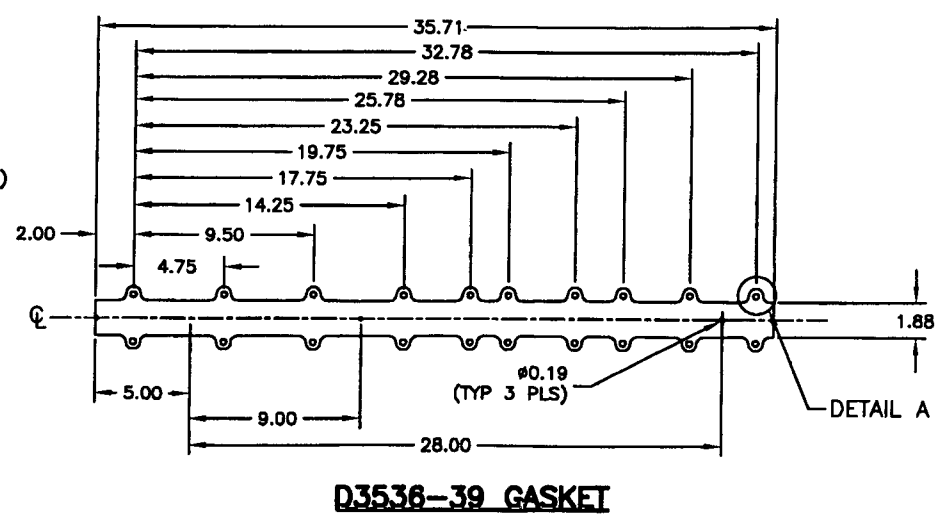
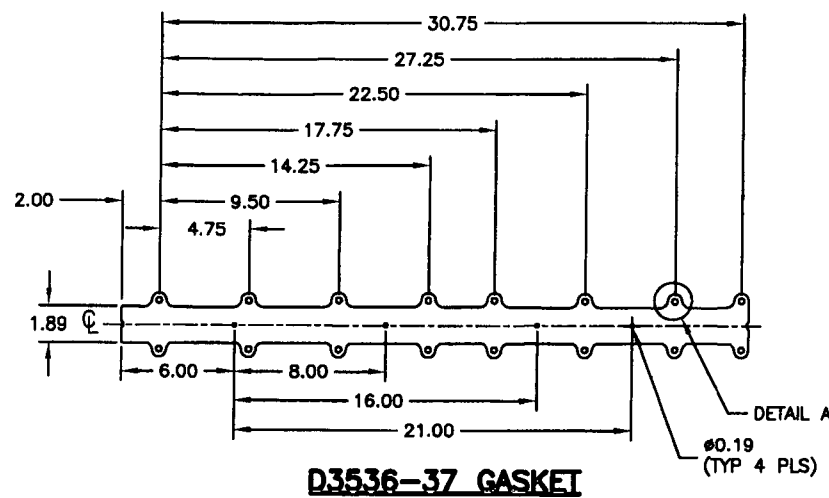
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		GASKET		SHEET 5 OF 6
				SCALE 1:10



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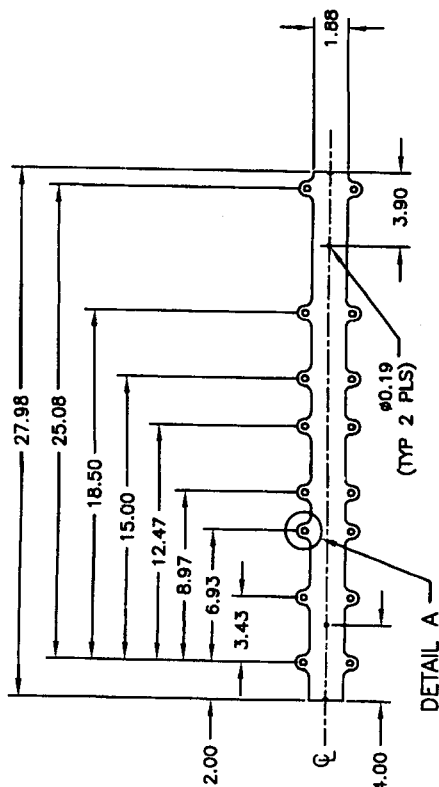
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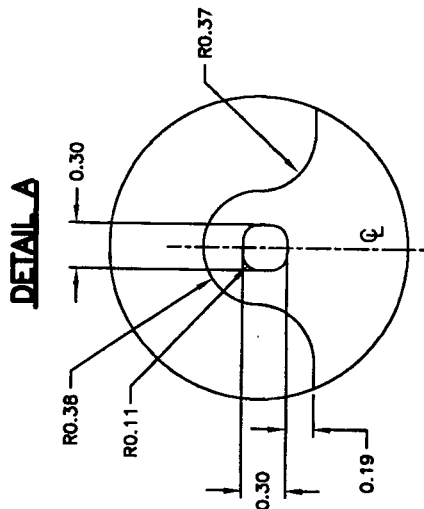


DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A
DATE 06.10.25		TITLE GASKET	SHEET 6 OF 6
			SCALE 1:10

07.02.12 **[Signature]**



D3536-41 GASKET



- NOTES**
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